

**Work Order ID 63508**

Wednesday, November 03, 2010 11:13:05 A

Page 1

Item ID: D205-706-013

Accept

Setup Start

Revision ID:

Stop

Item Name: Fuel Purge Canister

Start Date: 11/3/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 11/17/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10/11/03

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

IIN-D412-706

Rev A

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and create labels per PPP D205-706-013 CHG002

S 10/12/13

HJ for BG 10-11-15

110

0.00



Packaging

Packaging

Pick Kit

Memo

0.00

L 10/14/16 (1)

120

0.00



QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

0.00

S 10/12/13

(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 63508**

Wednesday, November 03, 2010 11:13:05 A

Page 2

Item ID: D205-706-013

Accept

Setup Start

Revision ID:

Stop

Item Name: Fuel Purge Canister

Start Date: 11/3/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 11/17/2010 Req'd Qty: 1.00

Customer:



Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD205-706-013								
	Location: <u>3/5</u>								
	PPP Rev: <u>5</u>								
140		0.00							
	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

10/12/13

10/12/14

ME  
10-12-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Wednesday, November 03, 2010 11:13:10 AM

Page 1

Work Order ID: 63508

Parent Item: D205-706-013

Parent Item Name: Fuel Purge Canister

Start Date: 11/3/2010


Required Date: 11/17/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:E 04.12.03 Remove AN6289-6D; Change Qty of AN924-6D  
KJ/JLM IPP Rev:F 10.05.10 as per  
chg002 DD verified :EC


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3-5A  Bolt		Purchased	No			110	Each	1,375.000	4	4			
--	--	-----------	----	--	--	-----	------	-----------	---	---	--	--	--

Location	Loc Qty	Loc Code
----------	---------	----------

ST350	1375	
105057	375	
115016	500	
115371	500	


11/6/05

AN814-6D  Plug		Purchased	No			110	Each	8.0000	1	1			
--	--	-----------	----	--	--	-----	------	--------	---	---	--	--	--

Location	Loc Qty	Loc Code
----------	---------	----------

ST329	8	
114742	8	

11/14/742

AN815-6D  Union-M-Flare		Purchased	No			110	Each	26.0000	2	2			
---	--	-----------	----	--	--	-----	------	---------	---	---	--	--	--

Location	Loc Qty	Loc Code
----------	---------	----------

ST329	26	
114348	1	
114523	5	
114988	20	

11/14/523

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Wednesday, November 03, 2010 11:13:10 AM

Page 2

Work Order ID: 63508

Parent Item: D205-706-013

Parent Item Name: Fuel Purge Canister

Start Date: 11/3/2010

Required Date: 11/17/2010

Start Qty: 1.00

Required Qty: 1.00

AN833-6D

Purchased

No

110

Each

13.0000

3 3



Elbow, Bulkhead-M-Flare

Location

Loc Qty

Loc Code

ST333

13

111650

7

115705

6

111650 16

115705 24

AN924-6D

Purchased

No

110

Each

16.0000

4 4



Nut

Location

Loc Qty

Loc Code

ST335

16

114742

6

114988

10

114988

AN960D10

NAS1149D0363J

Purchased

No

110

Each

8.0000

8 8



Washer

Location

Loc Qty

Loc Code

ST

6

107715

6

ST335

2

105792

2

AN960D10L

NAS1149D0332J

Purchased

No

110

Each

0.0000

4 4



Washer

AN960D16

NAS1149D0363J

Purchased

No

110

Each

0.0000

2 2



WASHER

1114348  
1115204

Wednesday, November 03, 2010 11:13:10 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

Wednesday, November 03, 2010 11:13:10 AM

Work Order ID: 63508



Parent Item: D205-706-013



Parent Item Name: Fuel Purge Canister

Start Date: 11/3/2010

Required Date: 11/17/2010

Start Qty: 1.00

Required Qty: 1.00

D2001-4

Manufactured No

110

Each

7.0000

1

1



Valve Assembly (1/4")

Location

Loc Qty

Loc Code

ST002

7

55525

1

56682

6

56682

D3262-041

Manufactured No

110

Each

2.0000

1

1



Canister Assembly

Location

Loc Qty

Loc Code

ST144

2

55184

2

~~56682~~ 10/11/10  
B63600 10/12/10

D3264-1

Manufactured No

110

Each

9.0000

2

2



Bracket

Location

Loc Qty

Loc Code

ST144

9

55733

3

59451

6

59451

D3297-1-0121

Manufactured No

110

Each

6.0000

1

1



HOSE ASS'Y

Location

Loc Qty

Loc Code

ST194

6

47419

1

58004

2

59542

3

58004

Wednesday, November 03, 2010 11:13:10 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Wednesday, November 03, 2010 11:13:10 AM

Page 4

Work Order ID: 63508

Parent Item: D205-706-013

Parent Item Name: Fuel Purge Canister

Start Date: 11/3/2010

Required Date: 11/17/2010

Start Qty: 1.00

Required Qty: 1.00

D3297-1-0130

Manufactured No

110 Each

7.0000

1 1

HOSE ASS'Y

Location

Loc Qty

Loc Code

ST194

7

46644

1

55069

3

59541

3

D3297-3-0350

Manufactured No

110 Each

7.0000

1 1

HOSE ASS'Y

Location

Loc Qty

Loc Code

ST194

7

46039

1

58005

3

59545

3

D3298-001

Manufactured No

110 Each

7.0000

1 1

Tube Assembly

Location

Loc Qty

Loc Code

ST195

7

48507

7

D3298-009

Manufactured No

110 Each

10.0000

1 1

Tube Assembly

Location

Loc Qty

Loc Code

ST195

10

47506

10

Wednesday, November 03, 2010 11:13:10 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D205-706-013

Parent Item Name: Fuel Purge Canister

Start Date: 11/3/2010

Required Date: 11/17/2010

Start Qty: 1.00

Required Qty: 1.00

D3299-1 Manufactured No

110 Each 14.0000



Fitting



1

Location

Loc Qty

Loc Code

ST050

14

42170

12

55540

2

D3299-3 Manufactured No

110 Each 20.0000



Fitting



1

Location

Loc Qty

Loc Code

ST050

20

42171

14

55530

6

D3301-1 Manufactured No

110 Each 24.0000



Placard



1

Location

Loc Qty

Loc Code

ST050

24

56601

12

56685

12

D3301-3 Manufactured No

110 Each 15.0000



Placard



1

Location

Loc Qty

Loc Code

ST050

15

47423

9

60250

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 6

Wednesday, November 03, 2010 11:13:10 AM

Work Order ID: 63508

Parent Item: D205-706-013

Parent Item Name: Fuel Purge Canister

Start Date: 11/3/2010

Required Date: 11/17/2010

Start Qty: 1.00

Required Qty: 1.00

D3302-1  
  
 Doubler

Manufactured No

110 Each

8.0000

1

1



Location

Loc Qty

Loc Code

ST143

8

47424

1

54577

3

60251

4

54577

D3302-3  
  
 Doubler

Manufactured No

110 Each

11.0000

1

1



Location

Loc Qty

Loc Code

ST142

11

54578

11

54578

MS21042L3  
  
 Nut

Purchased No

110 Each

1,890.000

4

4



Location

Loc Qty

Loc Code

ST300

1890

114784

890

115835

1000

114784

MS21919-WDG12  
  
 Clamp

Purchased No

110 Each

30.0000

1

1



Location

Loc Qty

Loc Code

ST307

30

107534

30

107534

Wednesday, November 03, 2010 11:13:10 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Wednesday, November 03, 2010 11:13:10 AM

Page 7

Work Order ID: 63508

Parent Item: D205-706-013

Parent Item Name: Fuel Purge Canister

Start Date: 11/3/2010

Required Date: 11/17/2010

Start Qty: 1.00

Required Qty: 1.00

MS21919-WDG16 Purchased No

110 Each

14.0000

2

2



Clamp

Location

Loc Qty

Loc Code

ST307

14

109147

2

111548

2

114523

10

MS21919-WDG9 Purchased No

110 Each

43.0000

5



Clamp

Location

Loc Qty

Loc Code

ST307

43

111578

43

MS21920-42 Purchased No

110 Each

10.0000

2



CLAMP(per MIL-DTL-8783C)

Location

Loc Qty

Loc Code

ST451

10

114113

2

115358

8

MS28778-6 Purchased No

110 Each

33.0000

5



Packing

Location

Loc Qty

Loc Code

ST294

33

112966

3

113422

20

114494

10

1114523  
5 ✓

111578  
2 ✓

1115358  
5 ✓

1113422 3X  
114494 2X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Wednesday, November 03, 2010 11:13:10 AM

Page 8

Work Order ID: 63508



Parent Item: D205-706-013



Parent Item Name: Fuel Purge Canister

Start Date: 11/3/2010

Required Date: 11/17/2010

Start Qty: 1.00

Required Qty: 1.00

MS35489-11

Purchase No

110

Each

22.0000

1

1

✓



GROMMET



*Le 10/11/16* ①

Location

Loc Qty

Loc Code

T295

22

109.66

22

109166

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## REFERENCE ONLY

## 5. PARTS LIST

Qty -011	Qty -013	Qty -015	Part Number	Description
X			D412-706-011	FUEL PURGE CANISTER INSTALLATION (212/412)
	X		D205-706-013	FUEL PURGE CANISTER INSTALLATION (205/214)
		X	D204-706-015	FUEL PURGE CANISTER INSTALLATION (204)
1	1	1	D2001-4	VALVE ASSEMBLY
		2	D2026-101	SCREW
1	1	1	D3262-041	CANISTER ASSEMBLY
2	2	2	D3264-1	BRACKET
1			D3297-1-0098	HOSE ASSEMBLY
	1		D3297-1-0121	HOSE ASSEMBLY
	1		D3297-1-0130	HOSE ASSEMBLY
1			D3297-3-0085	HOSE ASSEMBLY
1			D3297-3-0210	HOSE ASSEMBLY
	1		D3297-3-0350	HOSE ASSEMBLY
		1	D3297-5-0410	HOSE ASSEMBLY
1	1		D3298-001	TUBE ASSEMBLY
1			D3298-003	TUBE ASSEMBLY
1			D3298-005	TUBE ASSEMBLY
1			D3298-007	TUBE ASSEMBLY
1	1		D3298-009	TUBE ASSEMBLY
		1	D3298-011	TUBE ASSEMBLY
		1	D3298-013	TUBE ASSEMBLY
		1	D3298-015	TUBE ASSEMBLY
1	1	1	D3299-1	FITTING
1	1		D3299-3	FITTING
1			D3299-5	FITTING
1	1	1	D3301-1	PLACARD
1	1	1	D3301-3	PLACARD
1	1		D3302-1	DOUBLER
1	1		D3302-3	DOUBLER
		1	D3302-5	DOUBLER
		2	D3302-7	DOUBLER
2			D3329-1	BUSHING
4	4	4	AN3-5A	BOLT
1	1	1	AN814-6D	PLUG
3	2	2	AN815-6D	UNION
		1	AN816-6D	NIPPLE
1			AN832-6D	UNION
2	3	1	AN833-6D	ELBOW
		1	AN919-6D	REDUCER
5	4	1	AN924-6D	NUT
1			AN938-6D	TEE
4	4	2	AN960JD10L	WASHER
8	8	8	AN960JD10R	WASHER

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Revision: A

Date: 04.11.30

2	2		AN960JD916	WASHER
4	4	4	MS21042L3	NUT
	1	1	MS21919WDG12	CLAMP
	2		MS21919WDG16	CLAMP
		2	MS21919WDG6	CLAMP
		3	MS21919WDG7	CLAMP
2	5		MS21919WDG9	CLAMP
2	2	2	MS21920-42	CLAMP
10	5	5	MS28778-6	O-RING
1	1	1	MS35489-11	GROMMET

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Date: 04.11.30